

Work Order ID 130526

Friday, March 13, 2015 12:58:02 PM

130526

Page 1

Item ID: D5076-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 3/13/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLS Date: 1503-13 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5076	A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1- Cut as per Dwg

Dwg Rev: AProg Rev: A

2- Deburr

6061-040

6 15/03/21

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

6 15/03/21

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130526

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N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 3/13/2015 **Start Qty:** 6.00 ***6***

Required Date: 3/13/2015 **Req'd Qty:** 6.00 ***6***

Customer:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC									
Quality Control	Memo	0.00							
									DAS 38 9-89 MAR 23 2015
130	Form as per dwg	0.00							
130	Small Fab								
Brake NC									
Brake NC	Memo	0.00			DAS 30 9-89				15/03
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC									
Quality Control	Memo	0.00							
									DAS 38 9-89 MAR 24 2015

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Item ID: D5076-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 3/13/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>87245</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

DAS
38
9-89

MAR 26 2015

DAS
26
9-89

MAR 27 2015

Work Order ID 130526

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Item ID: D5076-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 3/13/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

15/3/3098

DIS.3.30

Picklist Print

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Page 1

Work Order ID: 130526

130526

Parent Item: D5076-1

D5076-1

Parent Item Name: Bracket

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 14.04.02 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased			No		sf	195.4306		11			
M6061T6S 040									**			02/15/2013/21	
6061-T6 .040 Sheet													

Location

Loc Qty

Loc Code

MAT021

195.4306

m130312

6.1135

m130585

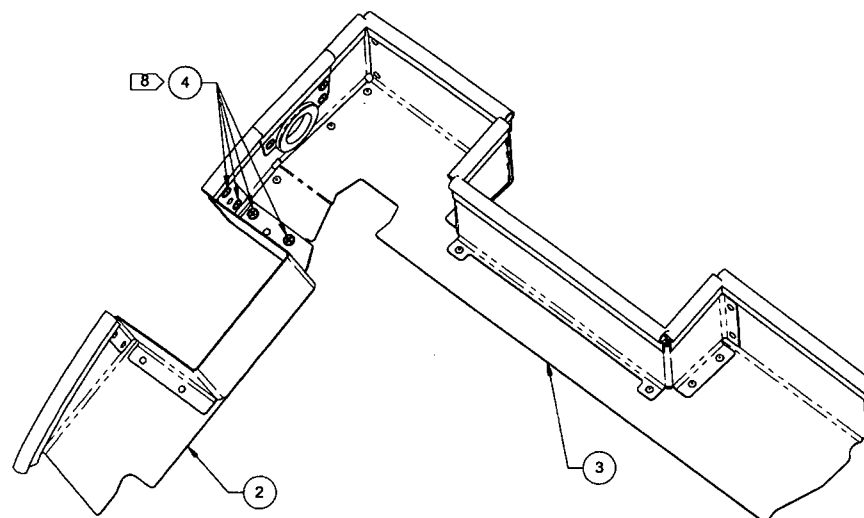
28.1501

m131352

161.167

11

ITEM	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D5076-041	FWD BRACKET ASSEMBLY
2	1	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
3	1	D5076-043	FWD INBOARD BRACKET ASSEMBLY
4	4	AN525-832R7	SCREW



D5076-041 FWD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.39 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

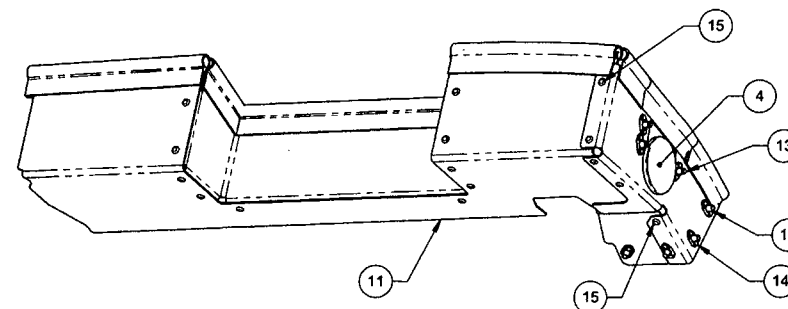
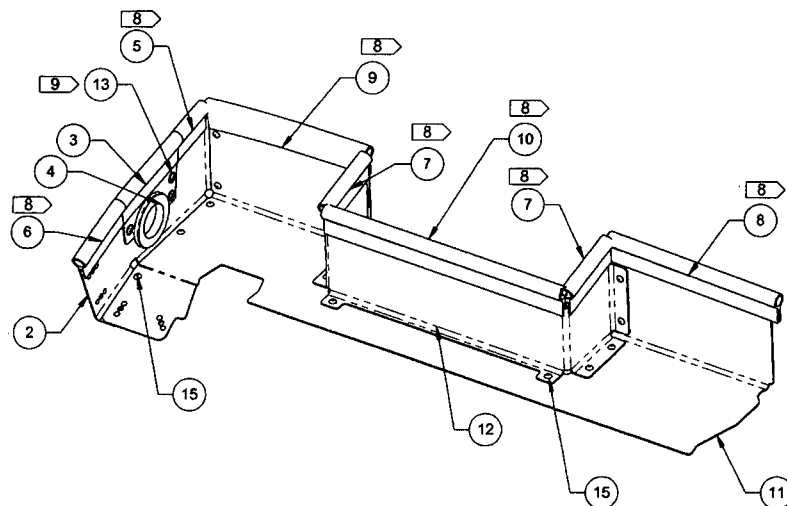
130526 MLO
1503-13

RELEASED
2014-03-31

A		NEW ISSUE		RF	14.03.11
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	RF			SHEET 1 OF 7	
CHECKED	DC	DRAWING NO. D5076		SCALE	
MFG. APPR.	DD	TITLE		NTS	
APPROVED	HS	BRACKET ASSEMBLY			
DE APPR.	DS	DATE 14.03.11			

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ITEM	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D5076-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-9	BRACKET
3	1	D4435-041	BRACKET ASSEMBLY
4	1	D4440-1	GROMMET
5	1	D4441-1-017	RUBBER SEAL
6	1	D4441-1-025	RUBBER SEAL
7	2	D4441-1-026	RUBBER SEAL
8	1	D4441-1-067	RUBBER SEAL
9	1	D4441-1-064	RUBBER SEAL
10	1	D4441-1-094	RUBBER SEAL
11	1	D5076-1	BRACKET
12	1	D5076-3	BRACKET
13	3	AN525-832R6	SCREW
14	14	MS20426AD3-3	RIVET
15	15	MS20470AD4-3	RIVET
16	7	MS21075L08	NUT PLATE
17	A/R	3M 1300/1300L	ADHESIVE



D5076-043 FWD INBOARD BRACKET ASSEMBLY

NOTES:

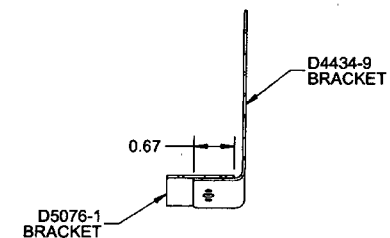
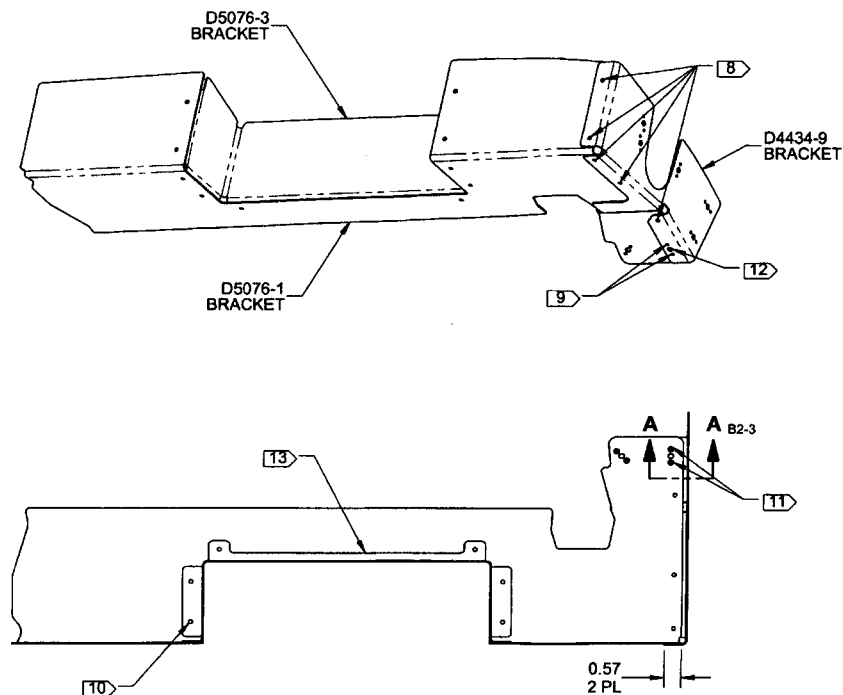
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3 PRIOR TO INSTALLING D4435-041.
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.01 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE COVER IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TORQUE SCREW TO 12-15 (in-lb)

RELEASED
2014-03-31

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D5076 REV. A
MFG. APPR.	DD	SHEET 2 OF 7
APPROVED	HS	TITLE BRACKET ASSEMBLY SCALE NTS
DE APPR.	D3	
DATE	14.03.11	

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SECTION A-A C4-3

D5076-043 FWD INBOARD BRACKET ASSEMBLY
AUXILIARY VIEW

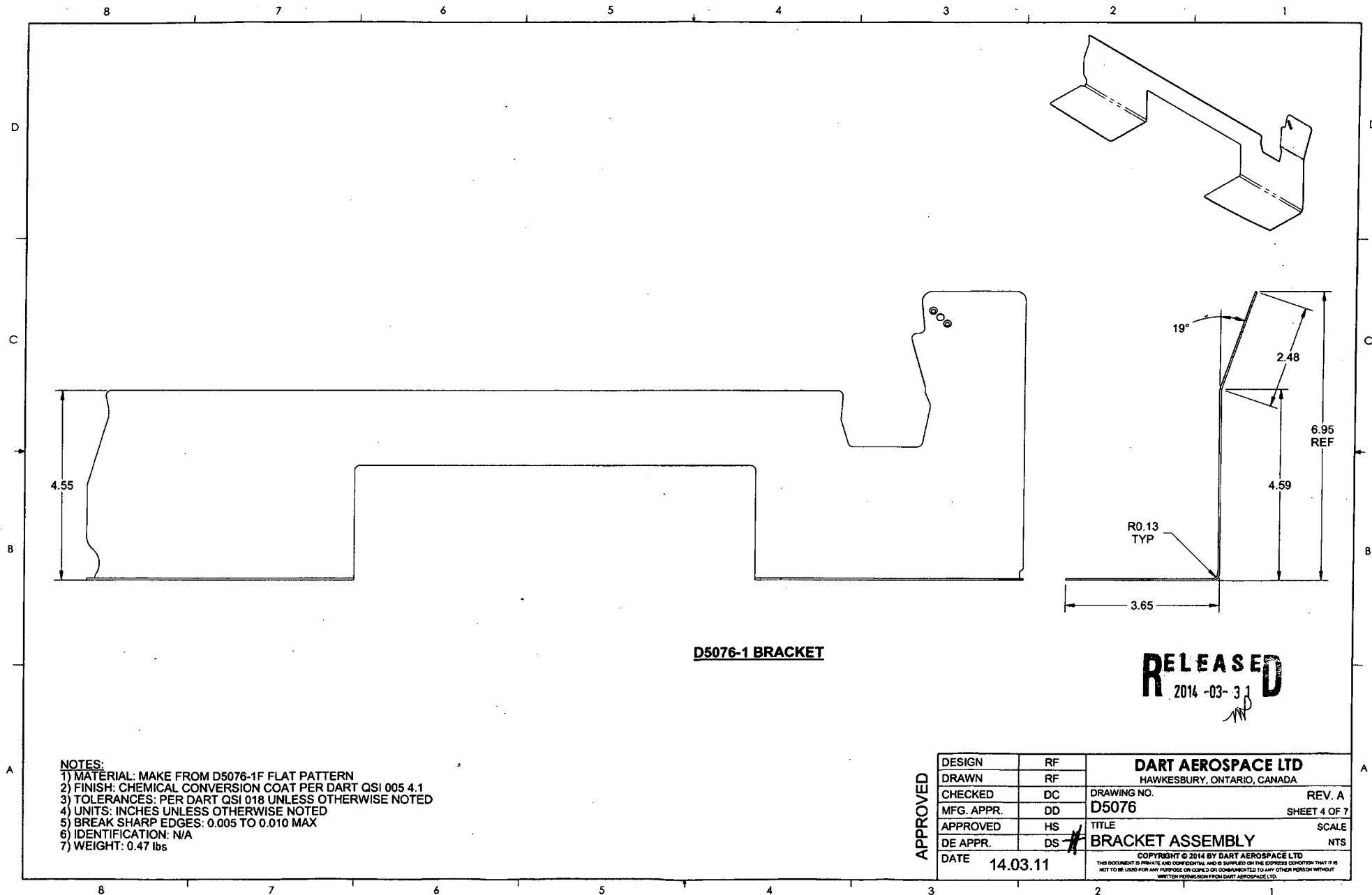
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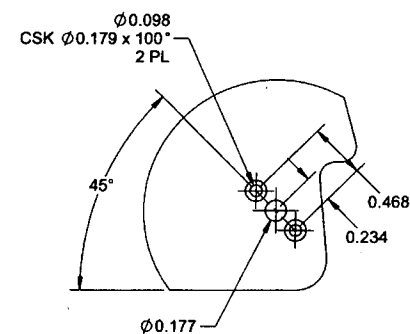
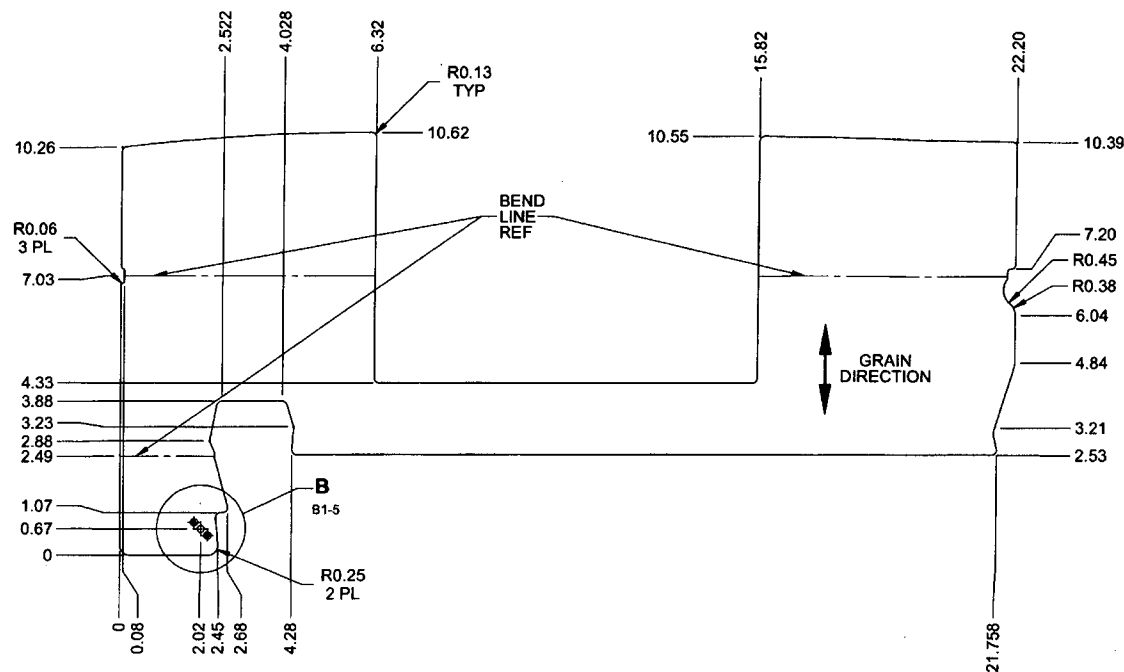
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) TRANSFER $\phi 0.129$ HOLES THRU 5 PLACES FROM D4434-9 TO D5076-1
- 9) TRANSFER $\phi 0.098$ HOLES THRU 2 PLACES FROM D4434-9 TO D5076-1
- 10) TRANSFER $\phi 0.129$ HOLES THRU 10 PLACES FROM D5076-3 TO D5076-1
- 11) CSK $\phi 0.179 \times 100^\circ$ ON THIS SIDE 2 PLACES
- 12) TRANSFER $\phi 0.177$ HOLE THRU FROM D4434-9 TO D5076-1
- 13) CENTRE D5076-3 INTO OPENING OF D5076-1

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2014-03-31

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DRAWN	RF	
CHECKED	DC	DRAWING NO. D5076 REV. A
MFG. APPR.	DD	SHEET 3 OF 7
APPROVED	HS	TITLE SCALE
DE APPR.	DS	BRACKET ASSEMBLY NTS
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DETAIL B 81-5

D5076-1F FLAT PATTERN BRACKET

NOTES:

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

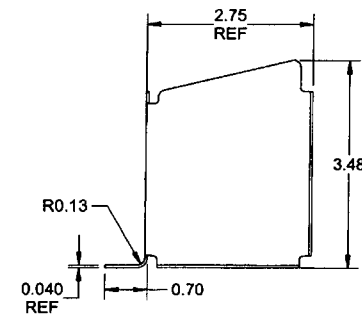
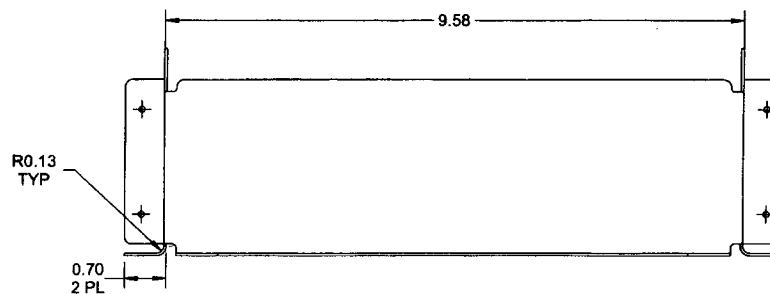
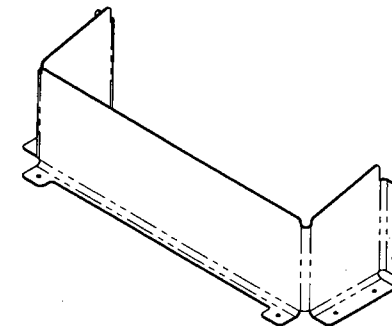
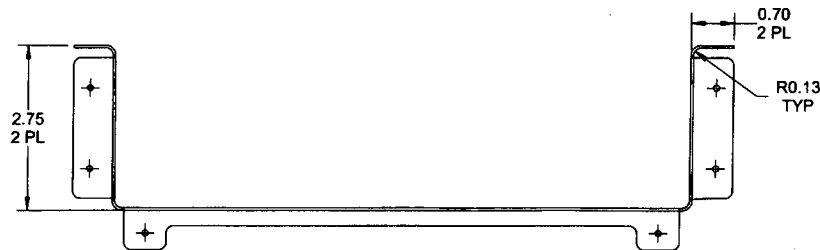
6) IDENTIFICATION: N/A

7) WEIGHT: 0.47 lbs

RELEASED
2014 -03- 31

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D5076	REV. A
MFG. APPR.	DD	SHEET 5 OF 7	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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D5076-3 BRACKET

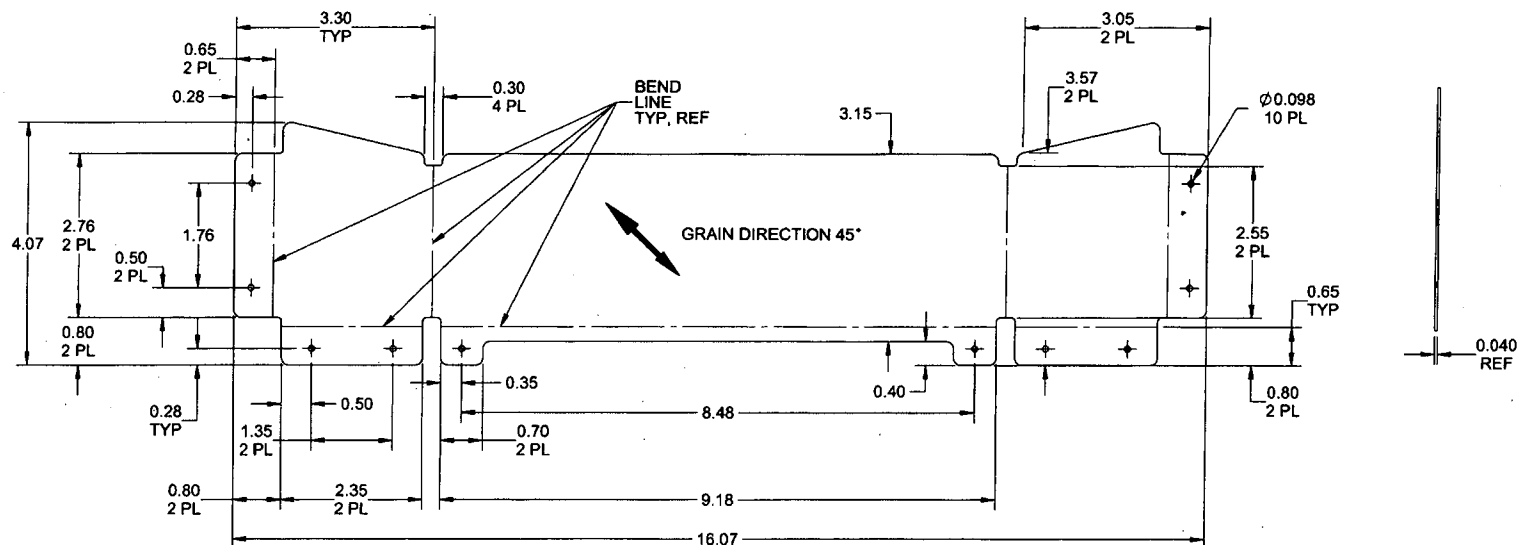
RELEASED
2014-03-31

NOTES:

- 1) MATERIAL: MAKE FROM D5076-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DD	D5076	SHEET 6 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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D5076-3F FLAT PATTERN BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DD	D5076	SHEET 7 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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2014-03-31